

SMALL FAB

[Dart Hawkesbury] Job Sheet - David, Logan

DEVIATION

4306

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7/7

8-21

		Dart Aerospace Ltd. 1270 Aberdeen St Hawkesbury, ON K6A 1K7 Canada Tel (613) 632-5200		RBEM633V3002102 Job Sheet 178183 				
Part No: RBEM633V3002102 Job Qty: 1 ea Part Name: Elastomeric Bearings Bolt Exchange 		Status: At Planning Priority: Medium Job Created: 5/28/18 Job Tracking No: Due Date: 7/16/18 Created By: Logan David Type: SOLD Description: Note: DWG RBEM633V3002102 Rev. 2 IPP Rev. A 18.05.22 new issue DP Verify DD Ship Via:						
Bill of Materials								
Job Routing								
Op No	Operation	Qty	Start Date	Due Date	Standard Setup hrs Run Hrs	Workcenter / Supplier	Lead Time	Sign-off
90	Start up Operation	1 Ea	7/16/18	7/16/18	0.00 0.00	Start Up Small Fab-4		MLC
110	Small Fab	1 pcs	7/16/18	7/16/18	0.00 0.00	Small Fab-4		MLC
120	QC	1 pcs	7/16/18	7/16/18	0.00 0.00	QC4		SEP 26 2018
130	Packaging	1 pcs	7/16/18	7/16/18	0.00 0.00	Packaging3-1		SEP 26 2018
140	QC21-FG	1 Ea	7/16/18	7/16/18	0.00 0.00	QC21		SEP 26 2018
Part Op 110 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 to Pelican case Descriptions: APP-1400-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard RBEM633V3002102-25 to RBEM633V3002102-29 from as per DWG. 6-Glue foam to case and pack case as per DWG.								
Job BOM								
Part / Item	Component Name	Quantity	Operation	Container				
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	90-Start up Operation	5075949				
APP-1400-E	Case	1 Ea (1 ea)	90-Start up Operation	5089429				
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	90-Start up Operation	5071040				
RBEM633V3002102-27	Bottom Foam	1 (1 ea)	90-Start up Operation	5089430				
RBEM633V3002102-29	Top Foam	1 (1 ea)	90-Start up Operation	5089431				
RBEM633V3002102-1	Lateral Elastomeric Bearing Bolt Exchange	1 Ea (1 ea)	110-Small Fab	5113737				
RBEM633V3002102-23	Thimble	1 Ea (1 ea)	110-Small Fab	5108607				
RBEM633V3002102-25	Placard	1 Ea (1 ea)	110-Small Fab	5099758				
RBEM633V3002102-9	Longitudinal Elastomeric Bearing Bolt Exchange	1 Ea (1 ea)	110-Small Fab	5113757				
Job Allocations								
Operation	Component Part	Required	Inventory	Allocated				
90-Start up Operation	97524A032	4	219	0				
	APP-1400-E	1	0	0				
	RB41011	1	903	0				
	RBEM633V3002102-27	1	0	0				
	RBEM633V3002102-29	1	0	0				
110-Small Fab	RBEM633V3002102-1	1	0	0				
	RBEM633V3002102-23	1	0	0				
	RBEM633V3002102-25	1	0	0				
	RBEM633V3002102-9	1	0	0				
Part Specifications								
Specifications could not be found.								

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Container No: S113771

Part: RBEM633V3002102

Job No: 178183

Serial No/Batch: S113771

Revision: 2

Inspector:

Exp Date:

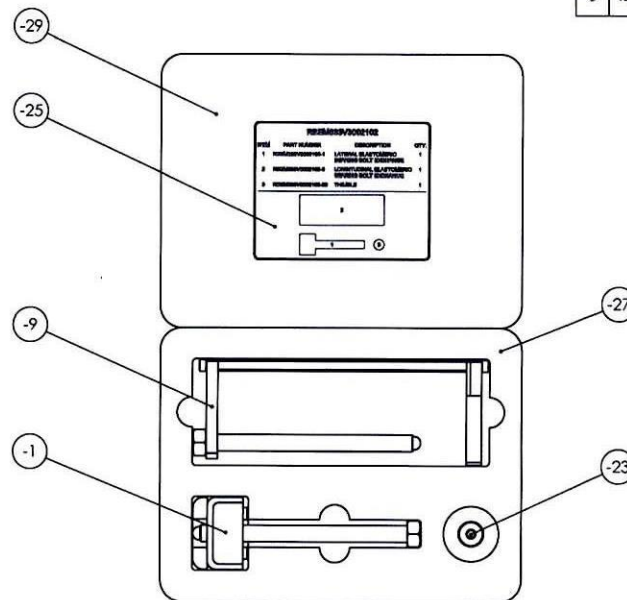
Instructions:

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Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-6200
Email: sales@dartaero.com
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Date: 09/26/10

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	6/17/2016	DPD	JAG
2	16-0180	-13, -18 CHD MATL WAS 1018/1020 CR S A36/1018/1020 HR, -27, -29 CHD MATL WAS Y-20, BLACK IS ETHAFOAM 220, BLACK, CHD VENDOR WAS (R. SPECIALTY) IS (CASE SOLUTIONS), -27 DELETED DIM 4X R.72, ADDED DIMS 4X 1.00, 4X 45°, -29 DELETED DIM 4X R.45, ADDED DIMS 4X .63, 4X 45°.	10/20/2016	DPD	JAG



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NO. 178183
20180712

ASSY QTY	ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
		X		-1	1	LATERAL ELASTOMERIC BEARING BOLT EXCHANGE			2
		1		-3		LATERAL BASE	1018/1020 CR		3
		1		-5		LATERAL PAD	WHITE DELRIN/ACETAL		4
		1		-7		LATERAL CLAMP PLATE	6061		5
		X		-9	1	LONGITUDINAL ELASTOMERIC BEARING BOLT EXCHANGE			6
		1		-11		LONGITUDINAL BACK PLATE	1018/1020 CR		7
		1		-13		LONGITUDINAL BASE PLATE	A36/1018/1020 HR		8
		1		-15		LONGITUDINAL BOLT PLATE	A36/1018/1020 HR		9
		1		-17		LONGITUDINAL PAD	WHITE DELRIN/ACETAL		10
		X	1	1		BOLT			11
		1		-21		THREADED ROD	B7	M14 X 2mm (MCMaster-CARR #93325A340) MODIFIED	12
				-23	1	THIMBLE	6061		13
				-25	1	PLACARD	PLASTIC		14
			B/O	-27	1	BOTTOM FOAM	ETHAFOAM 220, BLACK	3.95 X 9.08 X 11.98 (CASE SOLUTIONS)	15
			B/O	-29	1	TOP FOAM	ETHAFOAM 220, BLACK	1.20 X 9.08 X 11.98 (CASE SOLUTIONS)	16
		1		B/O	-31	HEX NUT	STEEL	M14 X 2mm (MCMaster-CARR #90592A032)	11
			2	B/O	-33	SOCKET HEAD CAP SCREW	STEEL	M6 X 1mm X 40mm (MCMaster-CARR #90128A268)	2
			2	B/O	-35	FLAT HEAD PHILIPS MACHINE SCREW	STEEL	M3 X 0.5mm X 10mm (MCMaster-CARR #91420A120) *	2
		4		B/O	-37	SOCKET HEAD CAP SCREW	STEEL	M6 X 1mm X 25mm (MCMaster-CARR #90128A265)	6
				B/O	-39	CASE	PLASTIC	PELICAN #APP-1400-E	N/S
			B/O		1	PLACARD	ALUMINUM	RB41011	N/S
ASSY 19	ASSY 9	ASSY 1							

NOTE:
REF. AIRBUS T/N: M633V3002101.

DART AEROSPACE	
TITLE ELASTOMERIC BEARING BOLT EXCHANGE	
DWG NO. RBEM633V3002102	REV 2
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 9° X ± .1 SURFACES ± 125	
1. BREAK ALL SHARP EDGES .015 ± .45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.3M-2009	
DRAWN BY: DUERFELDT	USED ON MODEL
CHECKED: CLOUGH	H175
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:4	DATE 4/5/2016 SHEET 1 OF 18